



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

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D350-636-015
Job Sheet 197906



Part No: D350-636-015

Job Qty: 1 pcs

Part Name: Skidtube LH, Run-on Landing Wearplates, DART(Apical) Cylind./Aerazur Float Comp.



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/18/19

Job Tracking No:

Due Date: 8/8/19

Created By: Marie Lajeunesse

Type: Stock

Description: SIOP

Note: DWG D4168-041 REV.C IPP rev:A 10.09.28 new issue DD verf:EC IPP Rev:B 11.04.14 ecn11-553 DD verf:EC IPP Rev:C 11.10.18 as per NCR 11-906 DD verf:EC IPP Rev:D 112.04.16 AS PER ECN 12-542 DD verf:EC IPP REV:E 13.08.28 PER ECN13-594 DD VERF:JLM IPP REV:F 18.11.12 AS PER DWG REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - 1	1 pcs	8/8/19		0.00	5.25	Skidtubes - 1		00
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
120	QC 10	1 pcs	8/8/19		0.00	0.00	QC 10 - 10		JUL 23 2019
							QC 10 - 18		
							QC 10 - 24		
							QC 10 - 43		
							QC 10 - 50		
							QC 10 - 58		
							QC 10 - 9		
130	QC 5	1 pcs	8/8/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		

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140 Handfinish - 1-1 Chemical-B4B	1 pcs	8/8/19	0.00 0.99	QC 5 - 30	
				QC 5 - 40	JUL 24 2019 40 9-89
				QC 5 - 61	
				QC 5 - 81	
				Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	★ JUL 27 2019
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150 QC 7	1 pcs	8/8/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	BE
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
				QC 7 - 61	
				QC 7 - 81	
160 Skidtubes - 2 - B4B	1 pcs	8/8/19	0.00 5.25	Skidtubes - 1 - B4B	
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	

					Skidtubes - 4 - B4B	TF BE
					Skidtubes - 5 - B4B	
					Skidtubes - 6 - B4B	
					Skidtubes - 7 - B4B	
170 QC 10	1 pcs	8/8/19	0.00 0.00		QC 10 - 10	DAS AUG 22 2019 50 9-89
					QC 10 - 18	
					QC 10 - 24	
					QC 10 - 43	
					QC 10 - 50	
					QC 10 - 58	
					QC 10 - 9	
180 QC 5	1 pcs	8/8/19	0.00 0.00		QC 5 - 10	DAS AUG 22 2019 68 9-89
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
190 Handfinish - 2-1 Pressure- B4B	1 pcs	8/8/19	0.00 0.33		Handfinish - 2 - 1 - B4B	BEB 19-08-22
					Handfinish - 2 - 2 - B4B	
					Handfinish - 2 - 3 - B4B	
					Handfinish - 2 - 4 - B4B	
200 Spray Paint - 2 - B4B	1 pcs	8/8/19	0.00 0.91		Spray Paint - 1 - B4B	AB 19-8-24
					Spray Paint - 2 - B4B	
					Spray Paint - 3 - B4B	
					Spray Paint - 4 - B4B	
210 QC 14	1 pcs	8/8/19	0.00 0.00		QC 14 - 15	BEB 19-08-26
					QC 14 - 2	
					QC 14 - 34	
					QC 14 - 41	
					QC 14 - 51	
					QC 14 - 58	
					QC 14 - 59	
					QC 14 - 9	
					QC 14 - 68	
					QC 14 - 40	
					QC 14 - 19	
					QC 14 - 43	
					QC 14 - 24	
					QC 14 - 61	
230 Handfinish - 4-1-Assembly- B4B	1 pcs	8/8/19	0.00 0.99		Handfinish - 4 - 1 - B4B	BEB 19-08-29
					Handfinish - 4 - 10 - B4B	
					Handfinish - 4 - 11 - B4B	
					Handfinish - 4 - 12 - B4B	
					Handfinish - 4 - 13 - B4B	
					Handfinish - 4 - 14 - B4B	

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240 QC 5	1 pcs	8/8/19	0.00 0.00	Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
250 Packaging 1-1 - Pick Kit - B4B	1 pcs	8/8/19	0.00 0.00	QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				Packaging 1 - 1 - B4B	
				Packaging 1 - 2 - B4B	
				Packaging 1 - 3 - B4B	
250 Packaging 1-1 - Pick Kit - B4B	1 pcs	8/8/19	0.00 0.00	Packaging 1 - 4 - B4B	
				Packaging 1 - 5 - B4B	
				Packaging 1 - 6 - B4B	
				Packaging 1 - 7 - B4B	
				Packaging 1 - 8 - B4B	
				Packaging 1 - 9 - B4B	
				Packaging 1 - 10 - B4B	
				Packaging 1 - 11 - B4B	
				Packaging 1 - 12 - B4B	
				Packaging 1 - 13 - B4B	
				Packaging 1 - 14 - B4B	
				Packaging 1 - 15 - B4B	
				Packaging 1 - 16 - B4B	
				Packaging 1 - 17 - B4B	
				Packaging 1 - 18 - B4B	
				Packaging 1 - 19 - B4B	
				Packaging 1 - 20 - B4B	
				Packaging 1 - 21 - B4B	
				Packaging 1 - 22 - B4B	
				Packaging 1 - 23 - B4B	
				Packaging 1 - 24 - B4B	
				Packaging 1 - 25 - B4B	
				Packaging 1 - 26 - B4B	
				Packaging 1 - 27 - B4B	
				Packaging 1 - 28 - B4B	
				Packaging 1 - 29 - B4B	
				Packaging 1 - 30 - B4B	
				Packaging 1 - 31 - B4B	

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40
9-89

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Pc

260 QC 4	1 pcs	8/8/19	0.00 0.00	Packaging 1 - 32 - B4B	
				Packaging 1 - 33 - B4B	
				Packaging 1 - 34 - B4B	
				Packaging 1 - 35 - B4B	
				Packaging 1 - 36 - B4B	
				QC 4 - 28	
260 QC 4	1 pcs	8/8/19	0.00 0.00	QC 4 - 58	
				QC 4 - 69	
				QC 4 - 9	
				QC 4 - 46	
				QC 4 - 68	
				QC 4 - 72	
				QC 4 - 74	
				QC 4 - 75	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
270 Packaging 3-1 - Stock - B4B	1 pcs	8/8/19	0.00 0.00	Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
275 DC - 1 - B4B	1 pcs	8/8/19	0.00 0.00	DC - 1 - B4B	
				DC - 2 - B4B	
280 QC 21 - FG	1 pcs	8/8/19	0.00 0.00	QC 21 - FG - 21	
				QC 21 - FG - 70	
				QC 21 - SA - 53	

Max B 9/10/2019

NL

SEP 10 2019

Part Op 110 - 1- Pick D2600-3 Bent 2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg
 Descriptions: D4168-1 3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill
 then ream holes using 0.500" reamer. PIN first side. Repeat process on second side. ***ENSURE PROPER
 POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE*** Drill pilot holes as per Dwg D4168
 sheet 4 (D4168-1 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail B) 4-

Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting, section H-H. Open to 0.500" using hole saw. VERIFY AND RECORD FWD BEND ANGLE. 5- Drill tow ring hole using DT9616 detail "A" 6- Drill most FWD wearplate hole using DT9678 locating off of 66.54" hole. 7- Open up holes of Detail A to 0.297" (total of 2 holes per side) and .201" (total of 1 hole per side using DT9616) 8- Weld D2744 Cap as per Dwg D4168 and QSI 004. Fill grooves in bend left from bending as per QSI 004 A/R Aluminum Rod batch: 139011 9- Grind welds flush as per Dwg D4168

120 - QC10 (QC10- Inspect visual per QSI004- ground welds)

130 - QC5 (QC5- Inspect part completeness to step on W/O)

140 - HandFinish1 (Chemical Conversion Coat per QSI005 4.1)

150 - QC7-2 (QC7-Inspect Chemical Conversion Coat)

160 - (Skid tubes) 1-Open up holes using hole saw of Detail C and ground handling section AL-AL to 0.625" (total of 8 holes per side) as per dwg D4168. 2-Open up holes using hole saw of Detail B to 0.750" (total of 4 holes per side) as per dwg D4168. 3- Open float hole to 0.500" using uni-bit (4 per side) section AJ-AJ Open wearplate holes to size as per dwg (4 holes per sides) , section CG-CG 4-Chamfer holes of Detail B, C, ground handling section AL-AL and float holes section AJ-AJ per dwg D4168 (welding instructions on sheet 8) 5-Deburr and blow out all chips from inside of tube 6- Prepare tube for welding, remove alodine as required. 7-Bond web D2739 in place as per QSI 015, let cure for 12hrs. A/R Sikaflex-291 batch: 174346 exp. date: 12/08/2019 ***ATTN: USE I-BEAM LOCATION AID (BLADE FITTING)*** 8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D4168 and D4170-1 & QSI004 (welding instructions on sheet 8) A/R Aluminum Rod batch: 139011 9- At section AJ-AJ drill out x-bolt spacer to 0.404" 10-Grind welds flush as per Dwg D4168 11-Spot face ground handling holes section (total of 4 places per side) as per dwg D4168, section AL-AL 12- C'bore section CG-CG. ADJUST TOOLING AS REQUIRED. VERF BY: _____ 13- Deburr holes, ensure tube is free of all scratches before sending to paint.

170 - QC10 (QC10- Inspect visual per QSI004- ground welds)

180 - QC5 (QC5- Inspect part completeness to step on W/O) ***VERIFY C'BOARD IS GOOD***

190 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings) HandFinish2 (Pressure Wash per QSI005 4.3/ Clean and remove all markings) Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

200 - Spray Paint (Spray Paint / NDT Room) 1- PRIME AS PER DWG AND QSI 005 4.2.1.3.3 PRIMER PRC DESOTO 515X349 BATCH: 5200299 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT

BATCH: 5204428

210 - QC14 (QC14- Inspect Spray Paint) Inspect for foreign object per QSI 024

230 - HandFinish4 (Assemble as per dwg) 1- Install inserts as per Dwg D4168 2-Inspect for Foreign Objects 3-Install blade fitting D3488-3, wearshoes and ground handling hardware as per dwg D4168 SIKA FLEX 241

BATCH: _____ EXP DATE: _____ 4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: _____ 5-Coat all exposed fasteners with "LPS Procyon" batch: _____

240 - QC5 (QC5- Inspect part completeness to step on W/O)

250 - Packaging1-3 (Pick Kit) If making a D350-636-215 pick kit will only requires: 1 X AN3C37A 1 X AN3C34A 1 X AN3C42A 2 X D3493-1

260 - QC4 (QC4- 100% Inspect kits for completeness)*****ensure antiseize is on AN8C21A bolts*****

270 - Packaging3-1 (Identify as per dwg & Stock Location: _____) Identify and pack for shipping as per PPPD350-636-015 Location :FG071

275 - DC (Document Control) record fwd angle: 89.9 Photocopy blue file and type labels per PPP D350-636-015 CHG 006

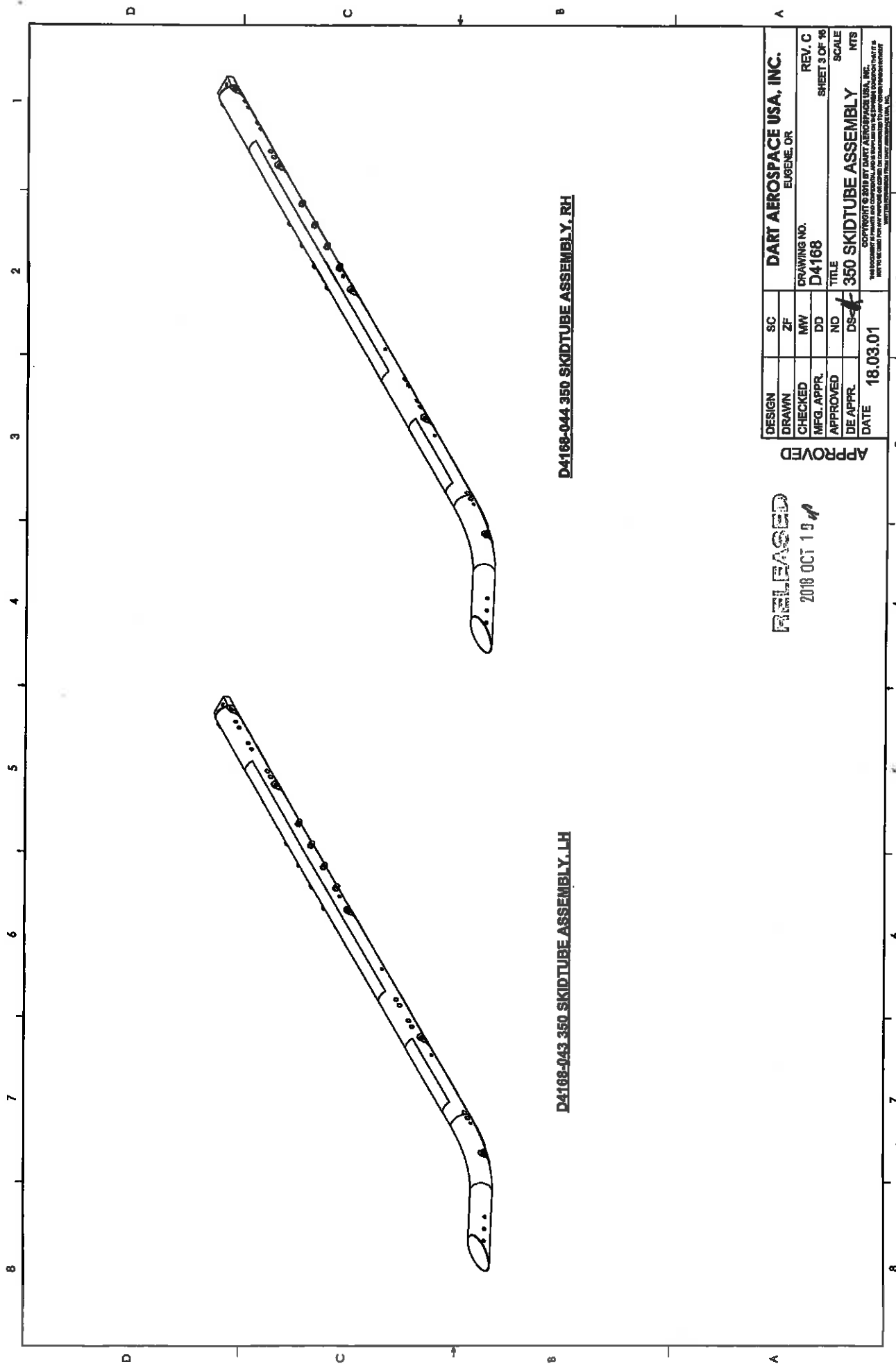
280 - QC21 (QC21- Final Inspection - Work Order Release)

Job BOM				M.U. 011583
Part / Item	Component Name	Quantity	Operation	Container
D2600-3-BENT-LH	Extrusion Bent LH	1 pcs (1 ea)	110-Skidtubes - 1	5197857
D2744	Cap	1 pcs (1 ea)	110-Skidtubes - 1	5192776
D2739	350 I-Beam	1 pcs (1 ea)	160-Skidtubes - 2 - B4B	5193443
D2743	Crossbolt Spacer	8 pcs (8 ea)	160-Skidtubes - 2 - B4B	5182366x6
D3490-1	Cross Bolt Spacer	4 pcs (4 ea)	160-Skidtubes - 2 - B4B	5194932x2
D3490-3	Cross Bolt Spacer	4 pcs (4 ea)	160-Skidtubes - 2 - B4B	5186296x4
ALS4-1032-225	Rivnut	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	519622x4
AN3C34A	Bolt	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5174308
AN3C36A	Bolt	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5186091-1
AN3C6A	Bolt	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	F4138009-2
AN6C44A	Bolt	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5167183
AN8C35A	Bolt	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5184405
D2745	Bushing	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5167090
D3486-3	Blade Fitting, LH	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5188184
D3492-1	Plug	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5184950
D3492-3	Plug	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5183175
D3631-1	Washer	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	6x5181407 12x5205 475
D3873-1	Bushing	7 pcs (7 ea)	230-Handfinish - 4-1-Assembly-B4B	5184192
D4154-041	Wearplate Assembly	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	#5209430
D4170-1	Bushing	4 pcs (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5195474
D4171-1	Bushing	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5175428
MS21043-3	Nut	5 Ea (5 ea)	230-Handfinish - 4-1-Assembly-B4B	5180790
MS21043-6	Nut	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5099569
MS21083C8	Nut	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5181777
NAS1149C0332R	Washer (AN960C10L)	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5167203-1
NAS1149C0363R	Washer (AN960C10)	9 Ea (9 ea)	230-Handfinish - 4-1-Assembly-B4B	5193136
NAS1149C0832R	Washer (AN960C816L)	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5135100
NAS1515H3L	Washer	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5076012
NAS1611-010	O-Ring	8 Ea (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5083559
NAS1611-013	O-Ring	8 Ea (8 ea)	230-Handfinish - 4-1-Assembly-B4B	3x5092499/5x5057 65F
AN3C37A	Bolt	1 Ea (1 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	5170279
AN3C42A	Bolt	1 Ea (1 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	5168418 ✓
AN8C21A	Bolt	2 Ea (2 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	5201295 ✓
D2741	Replacement Blade	1 pcs (1 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	5184404 ✓
D3493-1	Washer	2 pcs (2 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	5197663 ✓
MS21083C8 ✓	Nut	2 Ea (2 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	5199486 ✓
NAS1149D0863J	Washer	2 Ea (2 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	5192757 ✓
				5166718 ✓

Tue 9-3-19

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D2600-3-BENT-LH	1	9	0
	D2744	1	48	0
160-Skidtubes - 2 - B4B	D2739	1	12	0
	D2743	8	255	0
	D3490-1	4	153	0
	D3490-3	4	46	0
230-Handfinish - 4-1-Assembly-B4B	ALS4-1032-225	4	835	0
	AN3C34A	1	40	0
	AN3C36A	4	255	0
	AN3C6A	4	149	0
	AN6C44A	4	122	0
	AN8C35A	1	30	0
	D2745	8	64	0
	D3488-3	1	12	0
	D3492-1	8	67	0
	D3492-3	8	23	0
	D3631-1	8	376	0
	D3873-1	7	42	0
	D4154-041	1	12	0
	D4170-1	4	49	0
	D4171-1	1	26	0
	MS21043-3	5	934	0
	MS21043-6	4	99	0
	MS21083C8	1	93	0
	NAS1149C0332R	4	4,430	0
	NAS1149C0363R	9	695	0
	NAS1149C0832R	1	294	0
	NAS1515H3L	4	181	0
	NAS1611-010	8	219	0
	NAS1611-013	8	116	0
250-Packaging 1-1 - Pick Kit - B4B	AN3C37A	1	119	0
	AN3C42A	1	49	0
	AN8C21A	2	121	0
	D2741	1	56	0
	D3493-1	2	17	0
	MS21083C8	2	93	0
	NAS1149D0863J	2	375	0
Part Specifications				
Specifications could not be found.				

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D4168-044 350 SKIDTUBE ASSEMBLY, RH

D4168-043 350 SKIDTUBE ASSEMBLY, LH

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	ZF	EUGENE, OR	
CHECKED	MW	DRAWING NO.	REV. C
MFG. APPR.	DD	D4168	SHEET 3 OF 10
APPROVED	NO	TITLE	SCALE
DATE	18.03.01	350 SKIDTUBE ASSEMBLY	NTS

RELEASED
2018 OCT 19

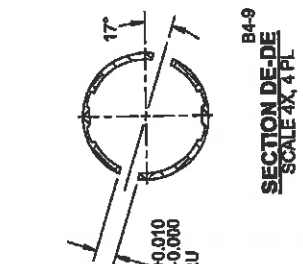
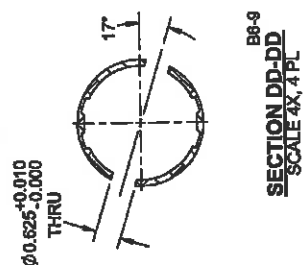
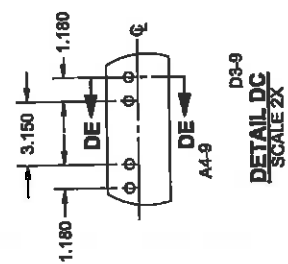
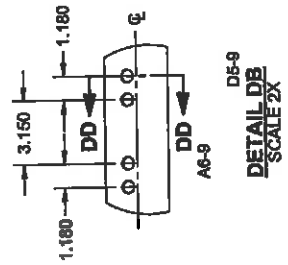
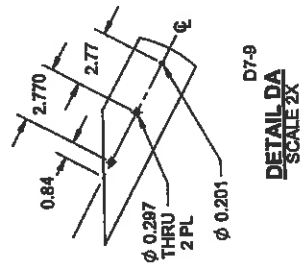
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MFG. APPR.	DD	D4168	SHEET 6 OF 18
APPROVED	NO	TITLE	SCALE
DE APPR.	DS-1	350 SKIDTUPE ASSEMBLY	NTS
DATE	18.03.01	COPYRIGHT © 2001 BY DART AEROSPACE USA, INC. REPRODUCTION IN WHOLE OR IN PART WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC. IS PROHIBITED. THE INFORMATION CONTAINED HEREIN IS THE PROPERTY OF DART AEROSPACE USA, INC. AND IS TO BE USED FOR THE PURPOSES SPECIFIED IN THE ORDER. NO PART OF THIS DOCUMENT IS TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM.	

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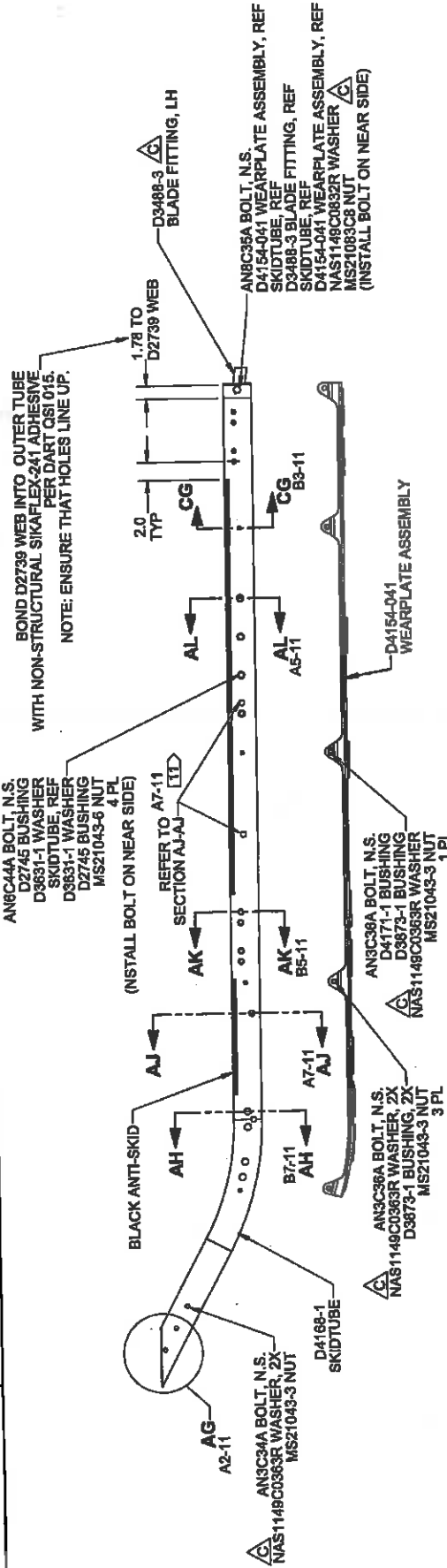


B8-9
SECTION DD-DD
SCALE 4X, 4 PL

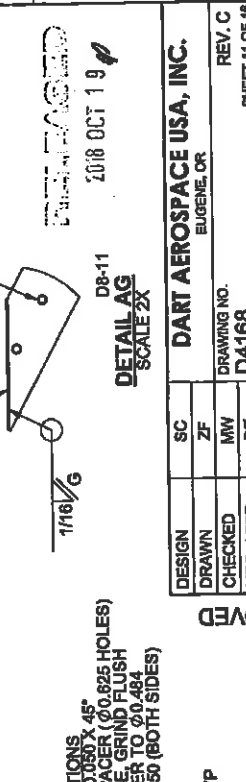
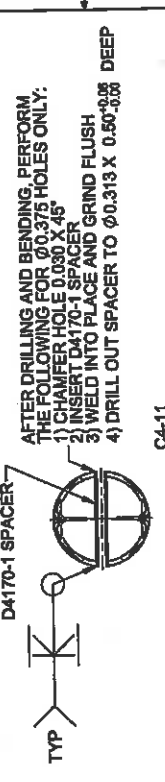
B4-9
SECTION DE-DE
SCALE 4X, 4 PL

**MAX ALLOWABLE
TWIST ON FWD BEND
(VIEW LOOKING FWD)**

2 3 4 5 6 7 8

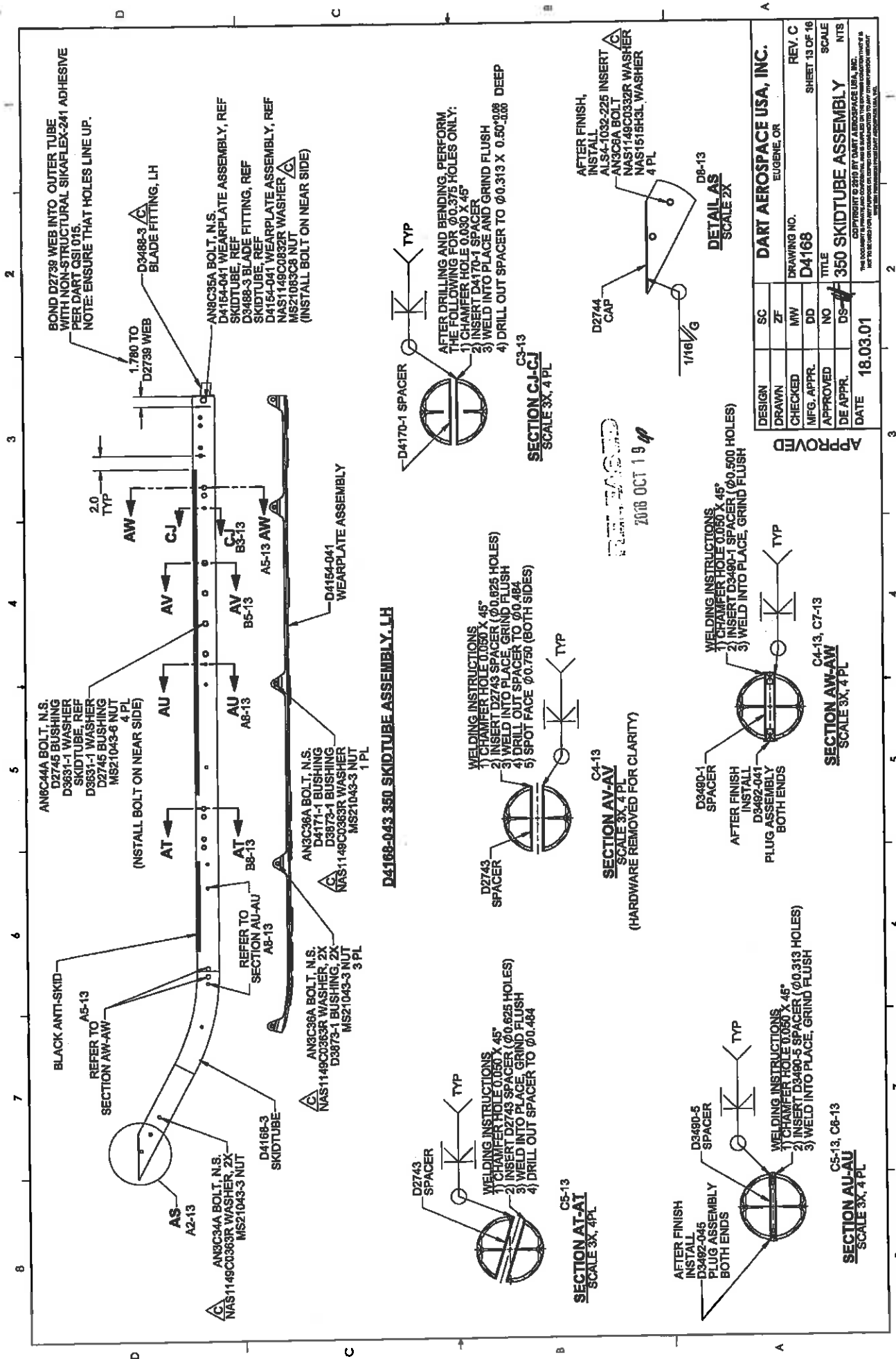


D4168-041 350 SKIDTUBE ASSEMBLY, LH



DESIGN	SC	REV. C
DRAWN	ZF	DRAWING NO. D4168
CHECKED	MW	DATE 18.03.01
MFG. APPR.	DD	TITLE 350 SKIDTUBE ASSEMBLY
APPROVED	NO	SCALE NTS
DE APPR.	DS	DATE 18.03.01

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SHEET 11 OF 18
350 SKIDTUBE ASSEMBLY
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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

DEPARTMENT/PROCESS

Skid-tube ☐
Machining ☐
Large Fab ☐

Cross tube ☐
Small Fab ☐
Finishing ☐

Eng. (Non-AW) ☐
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☐

Engineering ☐
Water Jet ☐
Supplier ☐
Quality ☐

Date: _____

Sequence #: _____

QTY Affected: _____

MRB (QS1042)

Description Work Order Deviation

Disposition

Completed By _____

Lead hand / Supervisor _____

QC / QA Coordinator _____

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Preservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

Pressure/Forced ☐
Bending ☐
Crushing ☐
Cracks ☐
Crimp/Kink/Ripple/Wave/Twist ☐
Marks/Chatter ☐
Mislabeled ☐
Contamination ☐
Misaligned/off center ☐
BOM/Route ☐
Broken/Damage/Defect ☐
Incomplete/Unclear Instructions ☐
Drill Holes ☐
Fit/Function ☐

Power Loss/Surge ☐
Folio/Program ☐
Grain Direction ☐
Weld ☐
Wrong Stock Pulled ☐
Out of Sequence ☐
Off-set/Set-up ☐
Positioned Wrong ☐
Outside Tolerance ☐
Drawing ☐
Finish ☐
Part Lost/Missing ☐
Misread ☐

Other/Details: _____

Change Record

PAGE 1 OF 1

Part Number: D350-636-015/-016

Description: SKIDTUBE STD LH/RH w/ TRAINING WEARPLATE

[illegible]

7.0 PARTS LIST

D350-636-015/-016/-017/-018 SKIDTUBES AT CHG 006 AND SUBSEQUENT
D350-636-023/-024 SKIDTUBES AT CHG 001 AND SUBSEQUENT

Item	Qty -015	Qty -016	Qty -017	Qty -018	Qty -023	Qty -024	Qty -047	Part Number	Description
	X							D350-636-015	SKIDTUBE INSTALLATION, LH, AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE W/TRAINING WEARPLATE
		X						D350-636-016	SKIDTUBE INSTALLATION, RH, AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE W/TRAINING WEARPLATE
			X					D350-636-017	SKIDTUBE INSTALLATION, LH AIRCRAUISER/DART TRI-BAG FLOAT COMPATIBLE W/TRAINING WEARPLATE
				X				D350-636-018	SKIDTUBE INSTALLATION, RH AIRCRAUISER/DART TRI-BAG FLOAT COMPATIBLE W/TRAINING WEARPLATE
					X			D350-636-023	SKIDTUBE INSTALLATION, LH, STD COMPATIBLE W/TRAINING WEARPLATE
						X		D350-636-024	SKIDTUBE INSTALLATION, RH, STD COMPATIBLE W/TRAINING WEARPLATE
							X	D350-636-047	TRAINING WEARPLATE KIT (LH/RH)
1	1							D4168-041	SKIDTUBE ASSEMBLY, LH
1		1						D4168-042	SKIDTUBE ASSEMBLY, RH
1			1					D4168-043	SKIDTUBE ASSEMBLY, LH
1				1				D4168-044	SKIDTUBE ASSEMBLY, RH
1					1			D4168-051	SKIDTUBE ASSEMBLY, LH
1						1		D4168-052	SKIDTUBE ASSEMBLY, RH
*1	1							D4168-1	SKIDTUBE WELDMENT, LH
*1		1						D4168-2	SKIDTUBE WELDMENT, RH
*1			1					D4168-3	SKIDTUBE WELDMENT, LH
*1				1				D4168-4	SKIDTUBE WELDMENT, RH
*1					1			D4168-5	SKIDTUBE WELDMENT, LH
*1						1		D4168-6	SKIDTUBE WELDMENT, RH
**2	8	8	8	8	8	8		350A41-1027-20	SCREW
**3	8	8	8	8	8	8		23119AG120LE	WASHER
**4	8	8	8	8	8	8		22541N120	NUT
*5	1	1	1	1	1	1		AN8C35A	BOLT
*6A	1	1	1	1	1	1		NAS1149CO832R	WASHER
*7	1	1	1	1	1	1		MS21083C8	NUT
*8	1		1		1			D3488-3	BLADE FITTING, LH
*8		1		1		1		D3488-4	BLADE FITTING, RH
9	1	1	1	1	1	1		D2741	BLADE
10	2	2	2	2	2	2		AN8C21A	BOLT
11	2	2	2	2	2	2		NAS1149CO863J	WASHER
12	2	2	2	2	2	2		MS21083C8	NUT
*14	4	4	4	4	4	4		AN6C44A	BOLT
*15	8	8	8	8	8	8		D2745	BUSHING
*16	4	4	4	4	4	4		MS21043-6	NUT
*17	8	8	8	8	8	8		D3631-1	WASHER
*18	4	4	4	4	4	4		ALS4-1032-225	INSERT
*19	4	4	4	4	4	4		AN3C6A	BOLT
*20A	4	4	4	4	4	4		NAS1149CO332R	WASHER
*20B	4	4	4	4	4	4		NAS1515H3L	WASHER

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Revision: K

Date: 18.04.04

Item	Qty -015	Qty -016	Qty -017	Qty -018	Qty -023	Qty -024	Qty -047	Part Number	Description
*30	8	8	8	8				D3492-041	PLUG ASSEMBLY
*31	8	8						D3492-043	PLUG ASSEMBLY
*32			8	8				D3492-045	PLUG ASSEMBLY
***43	2	2	2	2				D3493-1	WASHER
*90	1	1	1	1	1	1	1	D4154-041	WEARPLATE ASSEMBLY
*91A	4	4	4	4	4	4	4	AN3C36A	BOLT ¹
91B	1	1	1	1	1	1	1	AN3C37A	BOLT ²
91C	1	1	1	1			1	AN3C42A	BOLT ³
*92	7	7	7	7	7	7	8	NAS1149CO363R	WASHER
92A			1	1				NAS1149CO363R	WASHER ³
*93	4	4	4	4	4	4	4	MS21043-3	NUT
*94	7	7	7	7	7	7	8	D3873-1	BUSHING
94A			1	1				D3873-1	BUSHING ³
*95	1	1	1	1	1	1	1	D4171-1	BUSHING ⁴
96							4	D4170-3	SPACER
*97	1	1	1	1	1	1	1	AN3C34A	BOLT
*98	2	2	2	2	2	2	2	NAS1149CO363R	WASHER
*99	1	1	1	1	1	1	1	MS21043-3	NUT

* PART OF D4168-041/-042/-043/-044/-051/-052

** TO BE SUPPLIED BY CUSTOMER

*** ONLY INSTALLED IF INSTALLING A DART FLOAT SYSTEM

¹ QTY USED MAY BE LESS ON SKIDTUBES WITH DART CYLINDRICAL OR TRI-BAG FLOATS

² HARDWARE USED ON THE SKIDTUBES INSTALLED WITH DART CYLINDRICAL BAG FLOATS

³ HARDWARE USED ON THE SKIDTUBES INSTALLED WITH DART TRI-BAG FLOATS

⁴ HARDWARE NOT USED ON THE SKIDTUBES INSTALLED WITH DART TRI-BAG FLOATS